



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.7210

Job Sheet 210778



POSITIVE RECALL

EFFECTIVE 9-89 AUTH JUN 22 2020

RELEASED DATE

Part No: 650.7210

Job Qty: 5 pcs

Part Name: Bayonet Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/22/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/15/20

Description:

Type: SOLD

Note: DWG 650.7200 REV.PA1 IPP REV A 20.06.22 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

139 Value

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	SL-154 - 1	5 pcs	7/15/20	7/15/20	1.00 1.33	SL-154 - 1		JB - 20.07.12
110	QC 2	5 pcs	7/15/20	7/15/20	0.00 0.00	QC 2 - 1		
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		JB 20.07.12
						QC 2 - 63		
						QC 2 - 8		
						QC 2 - 66		
						QC 2 - 64		
						QC 2 - 65		



Container No: S287290



Part: 650.7210

Job No: 210778

Serial No/Batch: S287290

Revision: REV.PA1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/12/20

Plex 6/22/20 2:33 PM Dart.lajeunesse.marie

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	5 pcs	7/15/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
160	Packaging 3-1 - Stock - B4B	5 pcs	7/15/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B

20/07/20

DAS
28
9-89

JUL 28 2020

6/22/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	5 pcs	7/15/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	

Part Op **100** - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD316 FOLIO REV:
 Descriptions: AA DWG REV: DA1 2-Debur

110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 160 - Identify as per dwg & Stock
 170 - QC21- Final Inspection - Work Order Release

DAS JUL 20 2020
21
9-05

GA-TBD

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.625	303 Round Bar 0.625"	.3125 ft (.0625 ea)	100-SL-154 - 1	5250214

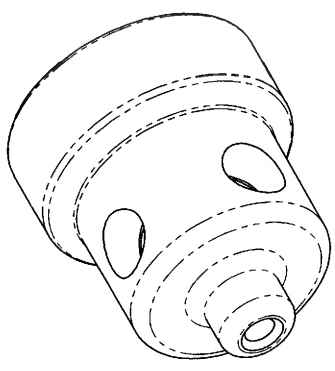
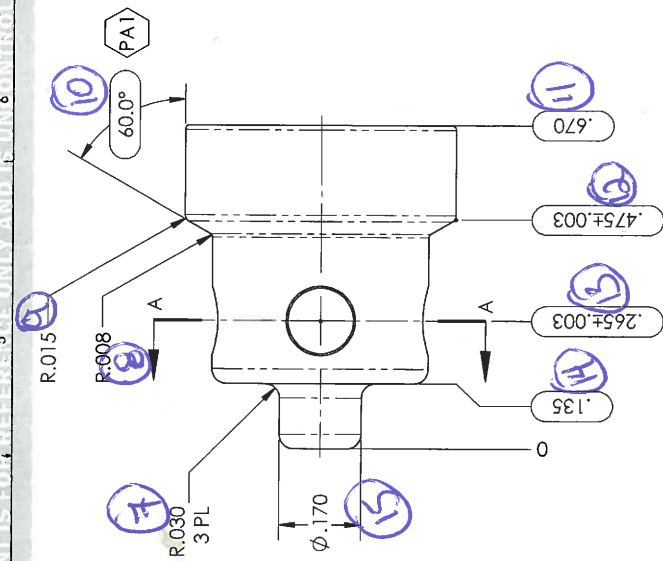
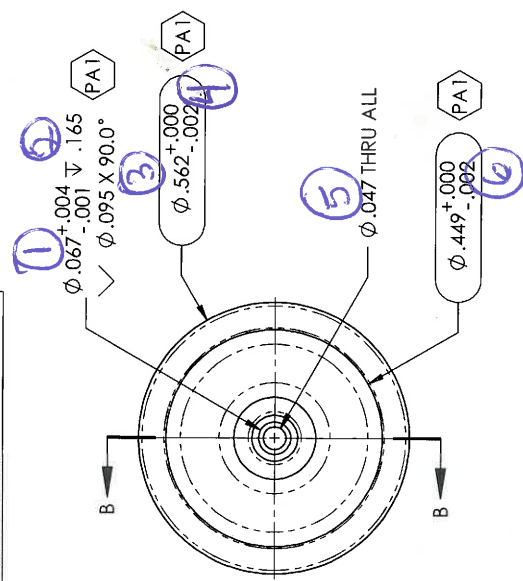
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M303R0.625	0	12	0

Part Specifications
Specifications could not be found.

Plex 6/22/20 2:33 PM Dart.lajeunesse.marie

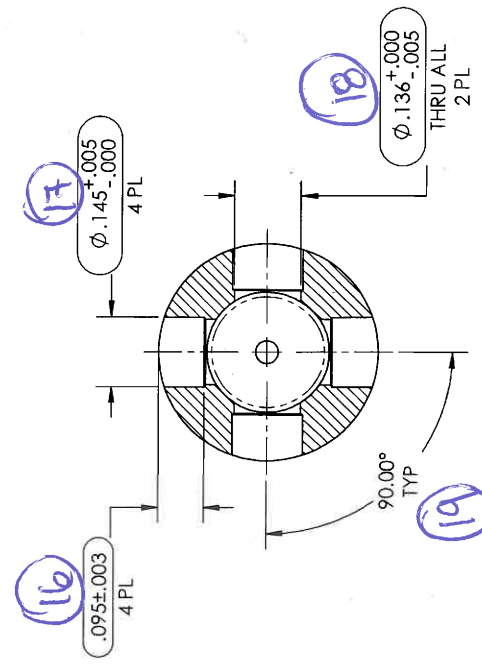
PRINTED ON 30% OF THIS DOCUMENT IS FOR REFERENCE ONLY AND IS UNCONTROLLED

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF DART INDUSTRIES. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART INDUSTRIES. DART AEROSPACE IS PROHIBITED.

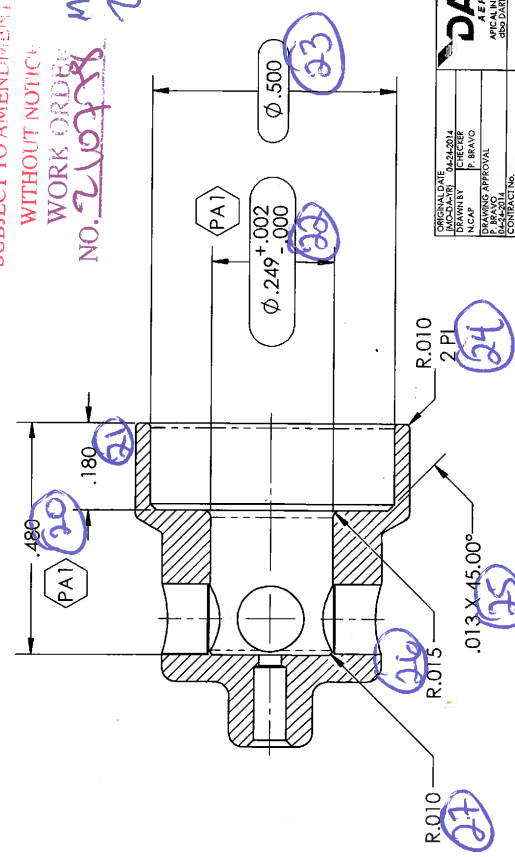


650.7210 7

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 210788
MUS 5-22
2006-22



SECTION A-A



SECTION B-B

DART 3030 ENTERPRISE CT. SUITE A 200 VESTAL, NY 13850 (760) 724-5300 DART AEROSPACE	
ORIGINAL DATE 01/11/2006 DRAWN N. CAP CHECKED P. BRAY APPROVAL CONTRACT NO.	BAYONET ASSEMBLY SIZE 1/4 CODE DWG. NO. 650.7200 B 1 07M26 SCALE NONE REV. PA1 SHEET 2 OF 3

DART AEROSPACE LTD

Work Order:

210778

Description: BAYONET ASSEMBLY – BODY

Part Number:

650.7210

Inspection Dwg: 650.7200

Rev: PA1

Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	Ø .067	+ .004 / - .001	.067	✓		GP (Ref)	.066 / .067 / .068
2	.165 DEEP	± .005	.165 ⁵	✓		vernier	JB-01
3	Ø .095 X 90.0°	± .005 X .5°	.093 ⁵	✓		vernier	JB-01
4	Ø .562	+ .000 / - .002	.560 ³	✓		mic	CNC-22
5	Ø .047	± .005	.046 ⁵	✓		GP (Ref)	.046 / .047 / .048
6	Ø .449	+ .000 / - .002	.447 ⁹	✓		mic	CNC-22
7	R .030	± .005	R .030	✓		RG (Ref)	1/32
8	R .008	± .005	R .008	✓		insert Rod	.008
9	R .015	± .005	R .015	✓		RG (Ref)	1/64
10	60.0°	± .5°	60°	✓		optical comp.	
11	.670	± .005	.671	✓		vernier	JB-01
12	.475	± .003	.4738	✓		optical comp.	
13	.265	± .003	.264 ⁸	✓		optical comp.	
14	.135	± .005	.136	✓		vernier	JB-01
15	Ø .170	± .005	.170 ⁴	✓		mic	CNC-22
16	.095	± .003	.096	✓		vernier + GP	JB-01 + .146 GP
17	Ø .145	+ .005 / - .000	.146 ⁸	✓		GP (Ref)	.145 / .150
18	Ø .136	+ .000 / - .005	.134	✓		GP (Ref)	.131 / .136
19	90.00°	± .5°	90°	✓		optical comp	
20	.480	± .005	.481	✓		vernier	JB-01
21	.180	± .005	.180 ⁵	✓		vernier	JB-01
22	Ø .249	+ .002 / - .000	.250	✓		GP (Ref)	.249 / .251
23	Ø .500	± .005	.500 ²	✓		inside mic	896032
24	R .010	± .005	R .010	✓		RG (Ref)	1/64
25	.013 X 45.00°	± .005 X .5°	.011 X 45°	✓		vernier	JB-01
26	R .015	± .005	R .015	✓		RG (Ref)	1/64
27	R .010	± .005	R .010	✓		end mill Rod (Ref)	

DAS
62

Measured by: JB 9-89	Checked by: Amk	QC Inspector:
Date: 20.07.12	Date: 20/07/20	Date:

Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
A	11-Jul-20	New Issue	MG	